

# Work Order ID 74483

Monday, October 03, 2011 10:29:01 AM



Page 1

Item ID: D2662-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH In 206

Start Date: 9/30/2011 Start Qty: 1000

Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 1000

Customer:

Reference:

Run Start



Approvals: Process Plan: MLJ Date: 11/10/03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev D								

100

0.00



HAAS CNC VERTICAL MACHINING #1

2 11-10-18

2

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.  
Inspect part number and batch number are programmed

JK

MACHINE AS PER FOLIO FB068 & DWG

DWG REV: D

FOLIO REV: HA

Pho →

110

0.00



CONVENTIONAL MILLING MACHINE

2 11-10-18

2

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

JK

W/O: 74483 <del>74483</del>		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D 2662-2 PAR #: NA Fault Category: Machining NCR: Yes No DQA: NA Date: 11-10-25  
 Resolution: use as is Disposition: use as is QA: N/C Closed Date: 11/10/25

NCR: 11-923		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-10-18	#110	Small bore outside of plane too high causing the part to be too thick .160" instead of .140" max. (op. 2) LCA operate error.		- fix and standardize THH4 in program to be like or closer to the others (20's) because these dimensions cannot be measured until the third op is completed. - ACCEPTABLE DEVIATION ON THE BASIS THAT THE PART DIMS ARE WITHIN TOLERANCE & PART FITS ON XTUBE.	11-10-18	S	J 11-10-19	S 11-10-19

NOTE: Date & initial all entries

**Work Order ID 74483**

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Item ID: D2662-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH In 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00	SL	11-10-18					
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	BA	11/10/19		2	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				2	0		6/10/19 coated

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




**Work Order ID 74483**

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Monday, October 03, 2011 10:29:01 AM

Item ID: D2662-2 Accept  Setup Start   
Revision ID: Stop   
Item Name: Saddle, RH In 206  
Start Date: 9/30/2011 Start Qty: 10.00  Cust Item ID:  
Required Date: 10/28/2011 Req'd Qty: 10.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<p><i>M 117745</i> <i>3200F</i> <i>3:00</i> <i>3:30</i></p> <p>Memo START TIME: <i>3:00</i> □OVEN TEMPERATURE: □FINISH TIME: <i>3:30</i></p>									
160  QC Quality Control	QC3- Inspect Part Finish	0.00							
<p>Memo</p> <p><i>2</i> <i>BK</i> <i>11-10-20</i></p>									
170  Packaging Packaging	Identify as per dwg & Stock Location: _____	0.00							
<p>Memo <i>ppn</i> <i>74983</i></p> <p><i>10/10/20</i> <i>(D)</i></p>									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74483**

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Item ID: D2662-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH In 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC21 - Final Inspection - Work Order Release  Memo	0.00  0.00							<i>Mio/20</i> <i>MF</i> <i>11-10-20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, October 03, 2011 10:29:07 AM

Page 1

Work Order ID: 74483

Parent Item: D2662-2

Parent Item Name: Saddle, RH In 206



Start Date: 9/30/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C ☐ 00.11.01 ☐ Removed P/O for Powder Coat - in house process ☐ EC  
IPP Rev:D As per Rev D 07-03-19 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	4.0000	1	10			
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Saddle Billet



11-10-19

Location

Loc Qty

Loc Code

MAT040

4

66965

1

69677

2

73768 ✓

1

74679

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 74483
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2662-2
<b>Inspection Dwg:</b> D2662 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.110	.115				
B	0.100	0.140		.160	.135				
C	1.125	1.145		1.138	1.136				
D	0.615	0.685		.685	.685				
E	0.240	0.260		.250	.251				
F	1.313	1.343		1.323	1.324				
G	0.210	0.230		.220	.219				
H	0.100	0.180		.140	.140				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.578	1.577				
K	0.235	0.240		.235	.239				
L	0.100	0.120		.112	.115				
M	0.990	1.010		.992	.990				
N	0.510	0.515		.512	.512				
O	5.990	6.010		5.996	5.996				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.313	.313				
S	0.315	0.322		.316	.316				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.797	.797				
W	0.540	0.560		.550	.544				
X	1.674	1.684		1.677	1.677				
Y	0.257	0.262		.257	.257				
Z	0.912	0.932		.918	.919				
AA	0.490	0.510		.500	.499				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: SL	Audited by: B.A
Date: 11-10-19	Date: 11/10/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

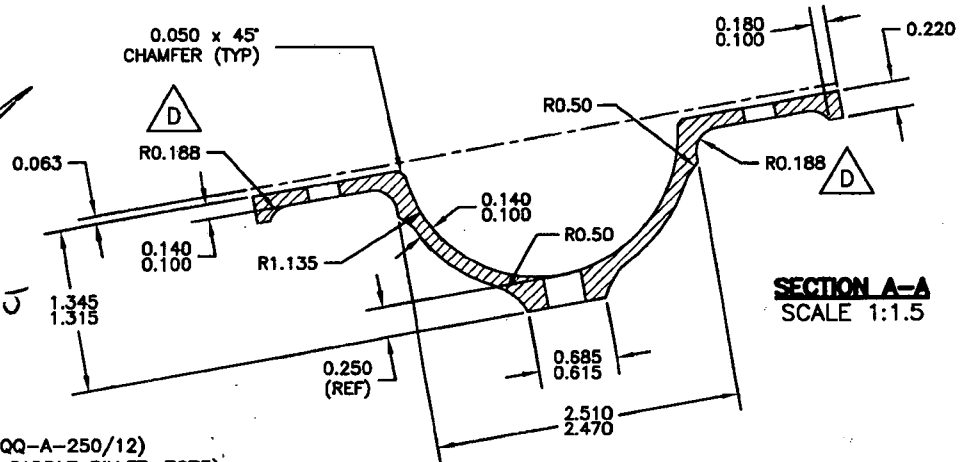
**DART**

DESIGN <b>A</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>A</b>	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

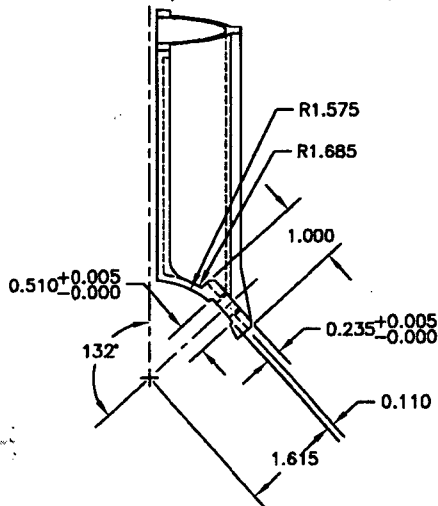
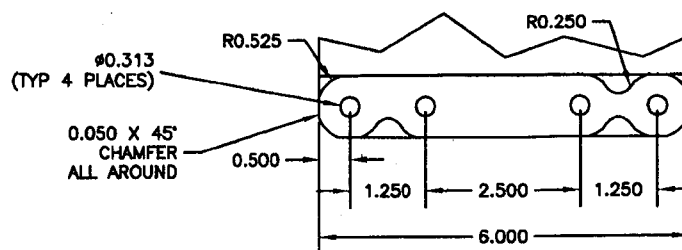
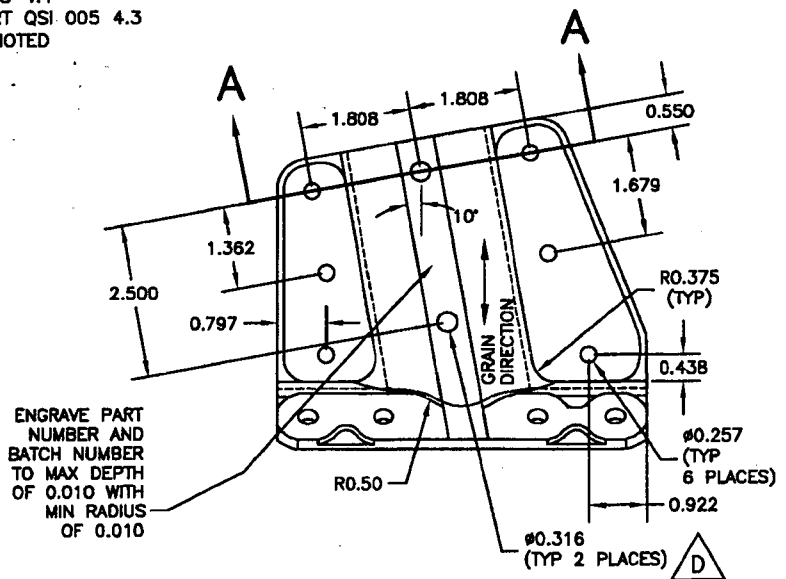
RELEASED

07.02.12

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **74483 M.C.J**  
**11/10/03**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)

**D2662-1 SADDLE INSIDE****Copyright © 1997 by DART AEROSPACE USA, INC.**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries